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D3199-1

Job Sheet 200131



Part No: D3199-1

Job Qty: 40 pcs

Part Name: Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/6/19

Job Tracking No:

Due Date: March 12

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV E SHEET 1 IPP Rev:C Removed Scribing 05-11-05 JLM IPP Rev:D As per Rev B 06-11-24 JLM
IPP Rev:E 11.03.31 as per ecn 11-531 DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	40 pcs	10/11/19	10/11/19	0.17	1.18	Waterjet - Flow		TF March 2, 2020
120	QC 8	40 pcs	10/11/19	10/11/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
130	Small Fab - 2 - B4B	40 pcs	10/11/19	10/11/19	0.01	1.76	Small Fab - 1 - B4B		
							Small Fab - 2 - B4B		
							Small Fab - 3 - B4B		
							Small Fab - 4 - B4B		

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140 QC 5	40 pcs	10/11/19	0.00 0.00	Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				Small Fab - 8 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
150 Powdercoat - 3 Grey Sand - B4B	40 pcs	10/11/19	0.00 0.45	QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
160 QC 3	40 pcs	10/11/19	0.00 0.00	Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
				QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
170 Packaging 3-1 - Stock - B4B	40 pcs	10/11/19	0.00 0.00	QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	

DAS

40

MAR 06 2020

9-89

BIB 20-03-09

DAS

40

MAR 09 2020

9-89

DAS

74

MAR 10 2020

9-89

				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180	QC 21 - SA	40 pcs	10/11/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

DAS

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MAR 11 2021

9-85

Part Op 100 - Cut as per Dwg D3199 Deburr if required
 Descriptions: 120 - (QC8- Inspect parts - second check)
 130 - (Small Fab) Form as per dwg D3199 use DT9723
 140 - (QC5- Inspect part completeness to step on W/O)
 150 - (Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3) START TIME: 7:45 FINISH TIME: 8:15 TEMP: 320"
 160 - (QC3- Inspect Part Finish)
 170 - (Identify as per dwg & Stock Location: _____)
 180 - (QC21- Final Inspection - Work Order Release)

5138839

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S20GA	304/316 .040 Sheet	3.9600 sf (.099 ea)	100-Waterjet - Flow - 1	S237385

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S20GA	4	126	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bracket	0.210inches + 0.005 - 0.001	0.215 0.209	0.212	
2	Bracket	0.575inches ± 0.010	0.585 0.565	0.571	
3	Bracket	1.090inches ± 0.010	1.100 1.080	1.0	
4	Bracket	2.015inches ± 0.010	2.025 2.005	2.015	
5	Bracket	2.971inches ± 0.010	2.981 2.961	2.973	
6	Bracket	1.830inches ± 0.010	1.840 1.820	1.829	
7	Bracket	4.830inches ± 0.010	4.84 4.82	4.828	
8	Bracket	4.030inches ± 0.010		4.028	

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only

Job: _____ Part No. _____		DISPOSITION		DEPARTMENT/PROCESS		MRB (QS1042)																	
Date: _____		Sequence #: _____		QTY Affected: _____		MRB (QS1042)																	
Description Work Order Deviation		Disposition																					
Root Cause <table border="1"><tr><td>Operator</td><td></td></tr><tr><td>Manufacturing Process</td><td></td></tr><tr><td>Equip/Tooling</td><td></td></tr><tr><td>Handling/Preservation</td><td></td></tr><tr><td>Material</td><td></td></tr><tr><td>Product Improvement</td><td></td></tr><tr><td>Process Improvement</td><td></td></tr><tr><td>Human Factors</td><td></td></tr></table>		Operator		Manufacturing Process		Equip/Tooling		Handling/Preservation		Material		Product Improvement		Process Improvement		Human Factors		FAULT CATEGORY					
		Operator																					
Manufacturing Process																							
Equip/Tooling																							
Handling/Preservation																							
Material																							
Product Improvement																							
Process Improvement																							
Human Factors																							
		Pressure/Forced		Contamination		Power Loss/Surge																	
		Bending		Misaligned/off center		Folio/Program																	
		Crushing		BOM/Route		Grain Direction																	
		Cracks		Broken/Damage/Defect		Weld																	
		Crimp/Kink/Ripple/Wave/Twist		Incomplete/Unclear Instructions		Wrong Stock Pulled																	
		Marks/Chatter		Drill Holes		Out of Sequence																	
		Mislabeled		Fit/Function		Off-set/Set-up																	
		Other/Details:																					
		Completed By																					
		Lead hand / Supervisor																					
		QC / QA Coordinator																					